

1   **Abstract of the Disclosure**

2   This invention relates to foundry binder systems, which will cure in the presence of sulfur  
3   dioxide and a free radical initiator, comprising (a) an epoxy resin; (b) an acrylate; (c) an  
4   alkyl ester of a fatty acid, wherein the alkyl group of the ester is an aliphatic hydrocarbon  
5   having from 4 to 8 carbon atoms, preferably butyl tallate; and (d) an effective amount of a  
6   free radical initiator. The foundry binder systems are used for making foundry mixes. The  
7   foundry mixes are used to make foundry shapes (such as cores and molds) which are used  
8   to make metal castings, particularly ferrous castings.

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